DQA:		. Date:			MODIC ODDED MON		NEO	22442165 / 11	DDATE				DART
QA Closed:		Date:			WORK ORDER NON-	٠	JNFOI	RIVIANCE / U		Worl	c Order up	date only	AEROSPACE
					DISPOSITION		-		AGAINST [	DEPA	RTMENT	PROCESS	
Work Orde	r:			_	Power!	. 1		Skid-tube	Crosstube	$\neg$		Water Jet	Engineering
Part N	o		<u>-</u>	·	Rework Scrap			Machining	Small Fab			d. Eng. Coor.	Quality
NCR N	o				Use-as-is Suspected Unapproved		Thern	noforming Large Fab	Finishing Composite		Rec/Stor	e/Packaging Supplier	Other
Root				Desci	ription of work order update		nitial	Act	tion	T	Sign &		
Cause	Date	Step	Qty		or non-conformance	Ch	ief Eng	Desci	ription		Date	Verification	QC Inspector
Design													
Doc/Data													
Equip/Tooling		l											
Handling/Pre													,
Material													
Operator		ŀ											
Offset/Setup													
Process													
Supplier													
Training													
Transport							-				!		
Unapproved													
						FA	ULT CA	regory					
Landir	ng Gear				General								
	Bending				Bend		Folio/F	Program		O	utside Dim	ensions	Pressure/Forced
	Centre N	ot Conce	ntric		BOM/Route		Grain			0	ver/Under	tolerance	Set-up
[	Cracks				Broken/Damage/Defect		Hardwa	are		P.	art Incorred	ct 「	Temperature/Cure
	Crimp/Ki	nk/Ripple	/Wave		Burrs		Inspect	ion Incomplete/U	nqualified	P	art Lost/Mi	ssing	Weld
	Cuffs				Contamination		Instruct	tions Incomplete/	Unclear	P.	art Moved		Wrong Stock Pulled
Ī	Crushing				Countersink		Misalig	ned/off center	Ī	P	ositioned <b>V</b>	Vrong	_
Ī	Heat Tre	at			Cut Too Short		Mislabe	eled	Ī	P	ower Loss/	Surge	Other
	Inspection	n Strip in	Tube		Drawing		Misread	d	_			_	
ľ	Marks/C	hatter			Drill Holes		Off-set						
	Turning S	Sequence			Finish	Γ	Out of	Calibration		_			
	Wave/Tv	vist in Tul	oe		Fit/Function		Out of	Sequence					

Work Ord June-12-13 9:1		102729		*102	779*							Pa	ige 2
Item ID: Revision ID: Item Name:	D2126 Seal			Accept	*N900	<b>040</b>	100	)*	Setup	Start Stop	*N:		
Start Date: Required Date Reference:	6/11/13 : 6/11/13	<b>Start Qty: 200.00 Req'd Qty: 200.00</b>	*20 *20		Cust Item I Customer:	D:				G			
Approvals:	Process  QC:		Date:	Tooling: SPC (Y/N):		ate:			Run	Start Stop	*N *N		
Sequence ID/ Work Center 130 *130* Packaging Packaging	D ·	Operation Description Identify as per dwg & Sto	ck Location:	Set Up/ Run Hours 0.00	Tool ID	Tool#	Plan Code	Accept Qty	Re Qt	•	Reject Nymber	Insp. Stam	

0.00

0.00

QC21- Final Inspection - Work Order Release

Memo

140

\*14**0**\*

Quality Control

13/7/4 A)

DQA:	· · · · · · · · · · · · · · · · · · ·	_ Date:										T Q A C
QA Closed:		Date:			WORK ORDER NON-	-CC	ONFO	RMANCE / UI		Work Order up	odate only	AEROSPACE
Work Orde	<b>r</b> -				DISPOSITION				AGAINST D	DEPARTMENT	/PROCESS	
Part N	0				Rework Scrap Use-as-is Suspected Unapproved		l .	Skid-tube  Machining  noforming  Large Fab	Crosstube Small Fab Finishing Composite	<del>_</del>	Water Jet d. Eng. Coor. re/Packaging Supplier	Engineering Quality Other
Root				Desci	ription of work order update	l	nitial	Act	ion	Sign &		
Cause	Date	Step	Qty		or non-conformance	Ch	ief Eng	Descr	iption	Date	Verification	QC Inspector
Design Doc/Data Equip/Tooling Handling/Pre Material Operator Offset/Setup Process Supplier Training Transport Unapproved								TECODY.				
1			· ··			FAI	JET CA	regory				
Landir	Cracks Crimp/K Cuffs Crushing Heat Tre Inspectic	lot Conce ink/Ripple 3 eat on Strip in	e/Wave ı Tube		General Bend BOM/Route Broken/Damage/Defect Burrs Contamination Countersink Cut Too Short Drawing Drill Holes Finish		Grain Hardwa Inspect Instruct Misalig Mislabe Misread Off-set	ion Incomplete/Ur tions Incomplete/U gned/off center eled	· -	Outside Dim Over/Under Part Incorre Part Lost/Mi Part Moved Positioned V Power Loss/	tolerance ct issing Vrong	Pressure/Forced Set-up Temperature/Cure Weld Wrong Stock Pulled Other
		wist in Tul			Fit/Function		1	Sequence				

**Picklist Print** 

June-12-13 9:12:53 AM

Work Order ID:

102729

Parent Item:

D2126

Parent Item Name: S

Seal

**Start Date:** 6/11/13

Required Date: 6/11/13

**Start Qty: 200.00** 

Required Qty: 200.00

**Comments:** 

IPP Rev: B99.03.29Re-format, ECN 175 (Dwg to Rev. C)DM

Comments.	11 1 Rev. D77.03.23	orce format, Derv	175 (176	, 10 100. 0)01									
Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
110750004		Purchased	No			110	Each	0.0000	1	200			01.10
Seal									_=			_/~	3/7///

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Page 1

DQA:	Date:			-		MODE ODDED NON	cc	אורטו	DR4ABICE / 11	DDATE			DART
QA Closed:			Date:			WORK ORDER NON-	-CC	NFOR	RIVIAINCE / U		Vork Order up	odate only	AEROSPACE
Mark Ords				·		DISPOSITION				AGAINST D	EPARTMENT,	/PROCESS	
Work Orde	er: –			<del>.</del>	_	Rework			Skid-tube	Crosstube	7	Water Jet	Engineering
Part N	do.					Scrap			Machining	Small Fab	Pro	d. Eng. Coor.	Quality
raiti	<b>'</b> '-				_	Use-as-is			noforming	Finishing	<b>⊣</b>	re/Packaging	Other
NCR N	No.					Suspected Unapproved			Large Fab	Composite	1	Supplier	
	_								·	· _	<b>_</b>		
Root					Desci	ription of work order update	ı	nitial	Act	tion	Sign &		
Cause		Date	Step	Qty		or non-conformance	Ch	ief Eng	Desci	ription	Date	Verification	QC Inspector
Design													
Doc/Data													
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Handling/Pre	Ш					:							
Material	Ш												
Operator	Ш												!
Offset/Setup	Ш												
Process	Ш												
Supplier	Ш												
Training	Ш				ŀ		l				ł		
Transport	Ш												
Unapproved			İ										
							FAI	ULT CAT	regory				
Landi						General	_	1 .		-		_	<b>¬</b>
	$\vdash$	Bending			ļ	Bend	<u> </u>	1	rogram	<u> </u>	Outside Dim	<u> </u>	Pressure/Forced
	┝─┥	Centre No	ot Concei	ntric		BOM/Route	_	Grain		-	Over/Under	<del></del>	Set-up
	1	Cracks				Broken/Damage/Defect	_	Hardwa		_	Part Incorre		Temperature/Cure
	$\vdash$	Crimp/Kir	rk/Ripple	/Wave		Burrs	<u> </u>	i	ion Incomplete/U	· · ·	Part Lost/M	issing	Weld
	$\vdash$	Cuffs				Contamination	<u> </u>	ł	ions Incomplete/	Unclear	Part Moved	L.	Wrong Stock Pulled
	_	Crushing				Countersink	<u></u>	1	ned/off center	 	Positioned \		_
	Н	Heat Trea				Cut Too Short	<u></u>	Mislabe		L	Power Loss/	Surge	Other
	-	Inspectio		Tube		Drawing	<u></u>	Misread	d				
	$\vdash$	Marks/Ch				Drill Holes	<u></u>	Off-set					
	Ш	Turning S				Finish			Calibration				
	1 1	Wave/Tw	ist in Tub	oe e	- 1	Fit/Function	1	Out of 9	Sequence				

H:/FORMS/Quality Assurance\approved QA/NCRWO RevH



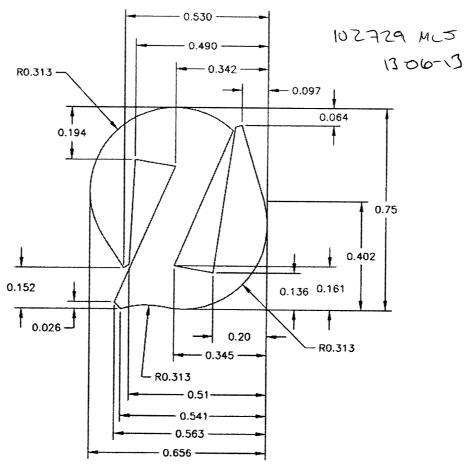
1:1 SCALE DETAIL

D2126-XXXX LOCKING SEAL LENGTH

EG: 87.5" LONG: D2126-0875 10" LONG: D2126-0100

POSSIBLE SUPPLIERS:

ACCURATE RUBBER ITEM NUMBER 110750004 PER DIE NUMBER 631



NOTES:

MATERIAL: 85 DUROMETER NATURAL RUBBER/SBR

ALL DIMENSIONS ARE IN INCHES

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED





	CHECKED	APPROVIDE	DAXI AEXOSPACE LID HAWKESBURY, ONTARIO, CANADA DRAWING NO.
	A CHECKED	A PORTOR OF THE	D2126 SHEET 1 OF 1
	DATE	/	TITLE SCALE
<u> </u>	99.03.15		LOCKING SEAL 3:1
	>	92.03.16	92.03.16 NEW ISSUE
	6	98.12.01	98.12.01 REDRAWN; ADD PATTERN
	ר	00074	ADDED COMPLETE DIMENSIONS, REMOVED

REFERENCE

T<sub>O</sub>

OTHER SUPPLIERS



Dart Aerospace Ltd. 1270 Aberdeen Street Hawkesbury, ON K6A 1K7

Tel: 613 632 9577 Fax: 613 632 1053

## **PURCHASE ORDER**

## Purchase Order ID PO20176

Purchase Order Date 6/14/2013 PO Print Date 6/14/2013

Page Number 1 of 1

Order From:

ACR GROUP INC. 12771 - NO. 5 ROAD RICHMOND, BC V7A 4E9 VC-ACR001

Ship To: DART AEROSPACE LTD

1270 ABERDEEN

HAWKESBURY, ON K6A 1K7

**CANADA** 

**Contact Name** 

**Vendor Phone** 

Ship To Contact

Ship To Phone

Reference

110750004

Vendor Part Number

**Delivery Comments** 

Line Comments

604 274 9955

Day & Ross collect

Buver

Chantal Lavoie

**Customer POID** 

Customer Tax #

10127-2607

Terms Currency Net 30 CAD

**FOB** 

Destination-Collect

REU

Ship Via: Ship Acct:

Line

Nbr

Description/ Req Date/ CD Mfg ID Taxable **Promise Date** Seal 6/28/2013

Req Qty/ Unit of Measure

500.00

Each

List Price Disc

Discounted Extended **Unit Price** Price

Yes

6/28/2013

Line Total:

\$1,750.00

\$550.00

\$1,750.00

110750006

Rubber Extrusion

6/28/2013

100.00

Each

AS PER DWG D3984 REV. A B103101

AS PER DWG D2126 REV. C B102729

6/28/2013

Yes

Line Total:

\$550.00

PO Total:

\$2,300.00

NO

Note: Pricing listed above is as per contract agreement between Dart Aerospace and the respective manufacturer.

No substitution or deviation without consent. Certificate of Conformity or Material Certification required

3

Change Nbr:

Change Date:

6/14/2013

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www.acrgroup.ca

12771 No. 5 Road Richmond, B.C. Canada V7A 4E9

Tel: 604-274-9955 Fax: 604-274-1013 Toll Free: 1-888-478-2237 **PACKING SLIP** 

CUSTOMER COPY

PACKING SLIP

ØØ147172

CUSTOMER NO.

10750

PST#

S DART AEROSPACE LTD
O 1270 ABERDEEN STREET
D HAWKESBURY, ON K6A 1K7
Canada

T O S DART AEROSPACE LTD
H 1270 ABERDEEN STREET
| HAWKESBURY ON K6A 1K7
| Canada

ò

DAT			SHIP VI	Andrew State (All Jacobs Mary Land 1917)		TER	MS	•
Ø7/Ø\$		DAY & DER NUMBER	ROSS DATE ORDERED	ACR GROUP INC.	NET 30 DAYS		CALES	PERSON -
	ð 176		Ø6/14/13	øø14717	a telephonomical programme and a superior of the forest programme and the superior of the supe	R	ОВ	GISON SALES
ORDERED	QUANTITY SHIPPED	B.O.	ITEM NUMBER	DESCRIP	FION	UNIT	UNIT PRICE	AMOUNT
5ØØ	500		110750004	#YAD-2126 LOCKING	G SEAL	FT		
100	100		110750006	EXTRUSION DIE # 5Ø+/-5 "A" NEO I	1234 DWG# D3984	FT		
				SUBTOT HST	[AL			
FRE	GHT:	Collec	t t		1437			





12771 No. 5 Road Richmond, B.C. V7A 4E9

Canada

Telephone : (604) 274-9955

Fax: (604) 274-1013

## **CERTIFICATE OF COMPLIANCE**

		Date :	06/20/2013
Customer:	Da	rt Aerospace Ltd	
Customer P.O. #	: PO20176		
ACR W.O. #:	14717201		110750004
Item Description:		Locking Seal	
ACR Compound	F-612		
Date Shipped:	June 20, 2013		

This Certifies that to the best of our knowledge the material delivered under this contract is in accordance with the terms of the contract, and with ACR Group quality standards.

Michael Reilander

(ACR GROUP INC. REPRESENTATIVE)